

Date:
User:Monday, 22/09/2008 2:01:00 PM
Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 42193 -1
 Estimate Number : 10281
 P.O. Number :
 This Issue : 22/09/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : MACHINED PARTS
 Previous Run : 39924
 Part Number : D3183043
 Drawing Number : D3183 REV C1
 Project Number : N/A
 Drawing Revision : C1
 Material :
 Due Date : 25/10/2008 Qty: 25 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: Pick: A 04.02.18 New issue KJ/DS
 Est Rev: B Changed Mat Size 08-06-26 JLM Verified By: EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M174B1500X02250	17-4 SS Bar 1.50 X2.250



(25)

Comment: Qty.: 0.4812 f(s)/Unit Total: 12.0304 f(s)
 Material: 17-4 SS Bar per AMS 5604/5643
 (M17-4-B1.500x02.25)
 Identify for D3183-043
 Batch: ~~m174B1500~~ x 25

2.0	BAND SAW	BAND SAW
-----	----------	----------



(25)

Comment: BAND SAW
 Cut blanks: (1.500" x 2.000") 5.500" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3183-3 as per Folio FA322 and Dwg D3183
 Identify as D3183-3

2-Deburr

3-Scribe batch number



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

INSPECT PARTS AS THEY COME OFF MACHINE

Review & Inspect for transit damage
 Ensure C of C attached

J.F. 08/12/09 (10)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 42193

Part Number: D3183043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

SECOND CHECK



Comment: SECOND CHECK

Inspect level 18

JL 08/12/09

6.0

D312121

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3121-21

Bolt

B43536

7.0

D3183045

Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3183-045 Bearing Ass

M42179

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3183-043 as per Dwg D3183.

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

233A

8/12/10

fox
SD

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/11

Job Completion

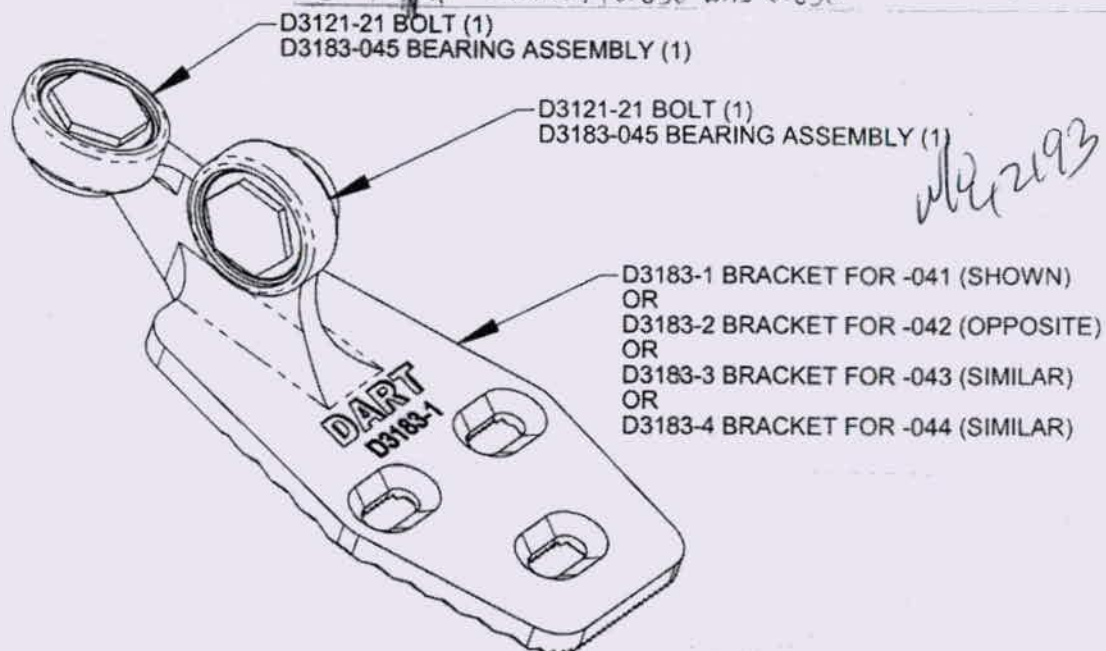


MF 08-12-10

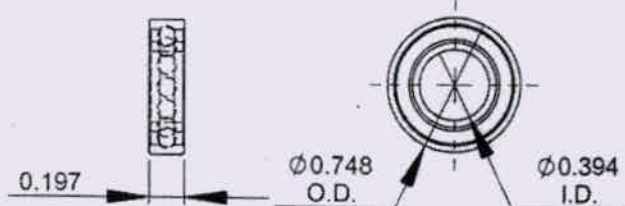


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3183	REV. 1 SHEET 1 OF 1
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	04.11.09	0.830 WAS 0.850	

RELEASED
04 03 01

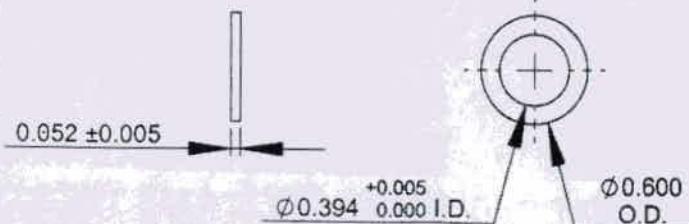


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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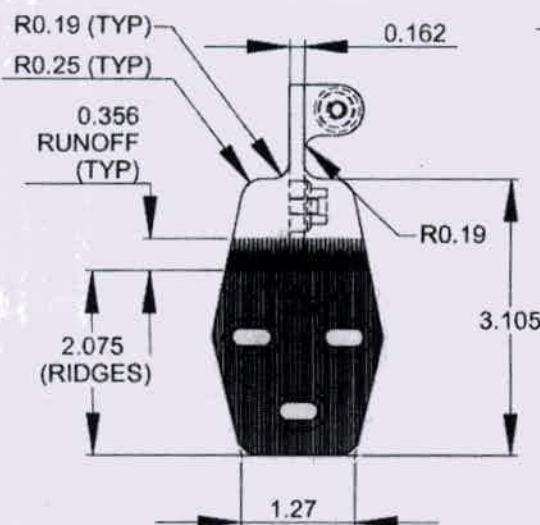
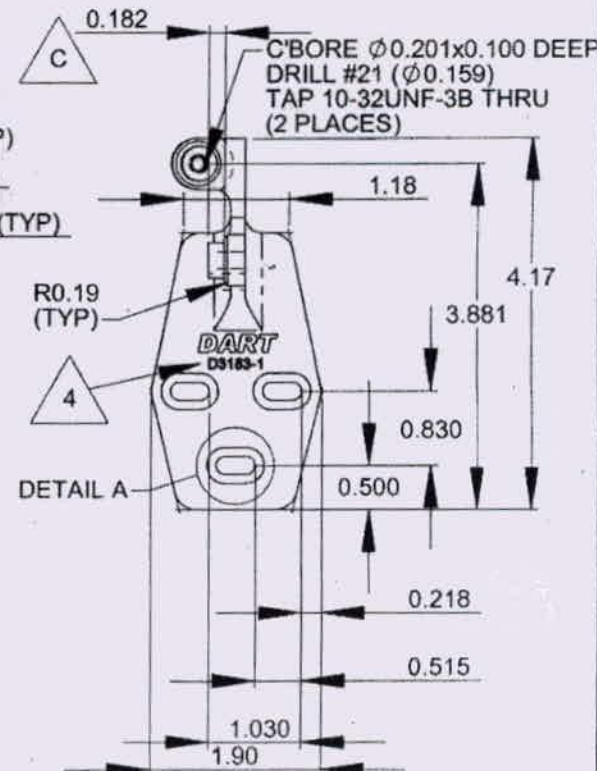
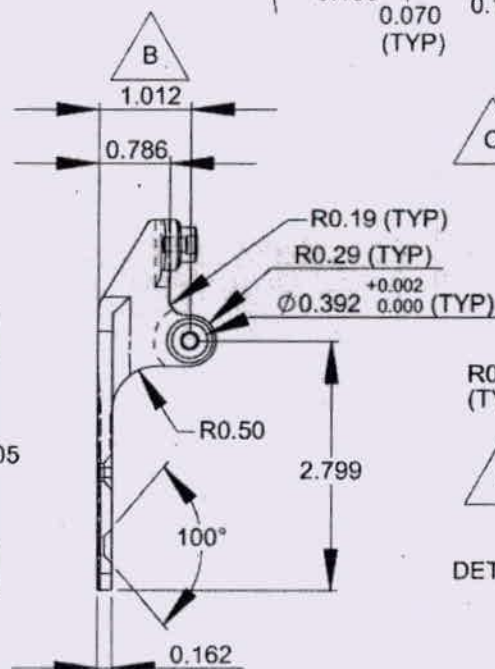
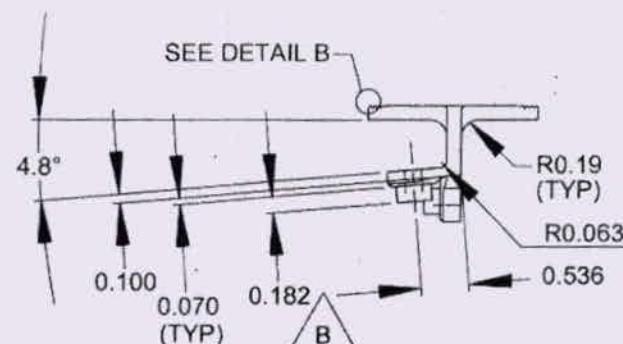
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DATE	DRAWING NO.	REV. C
04.02.17	D3183	SHEET 2 OF 4
TITLE	BRACKET ASSEMBLY	SCALE
		1:2

RELEASED
04 03 01



**D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE**

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

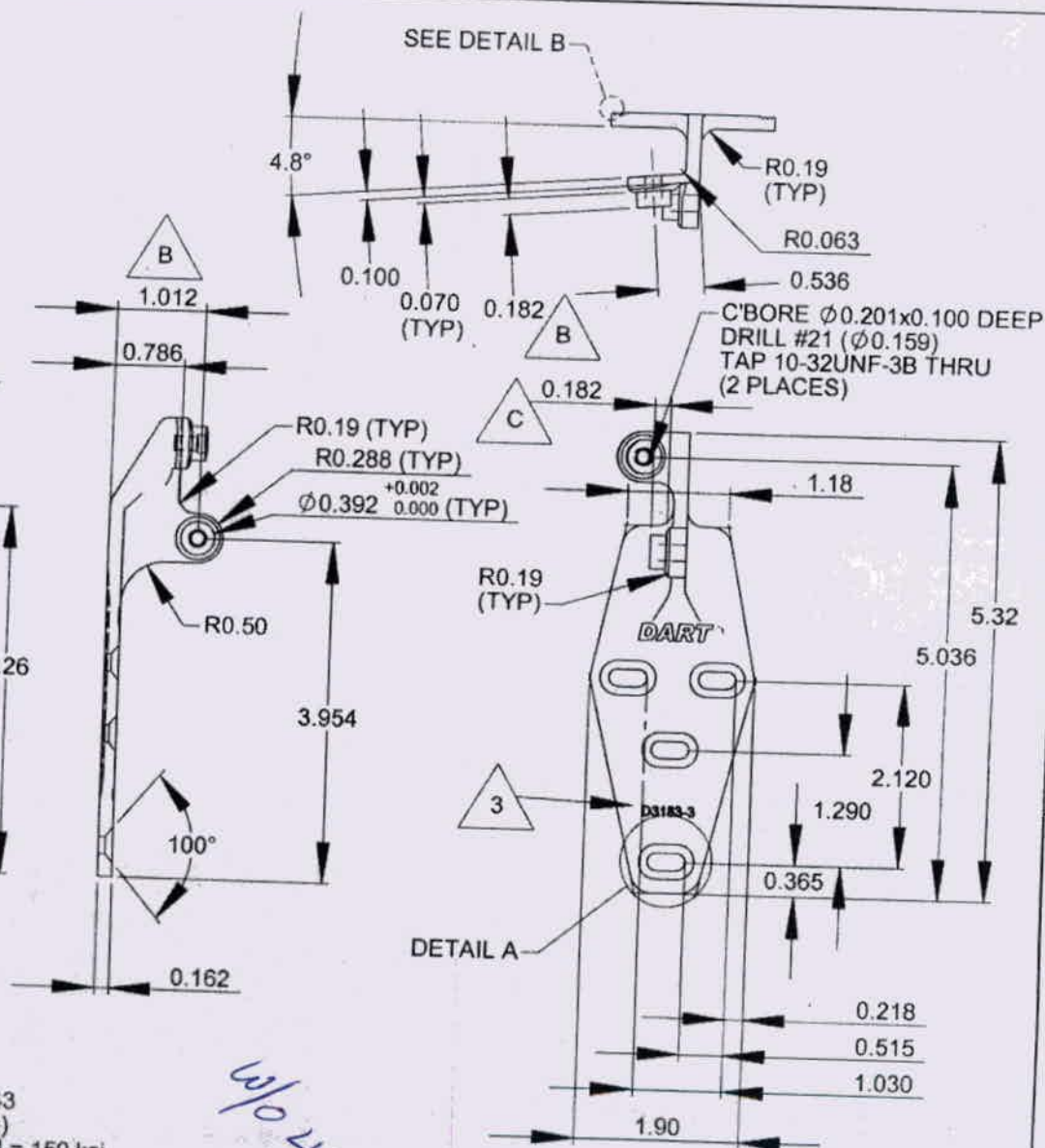
W/042193

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DATE	DRAWING NO.	REV. C
04.02.17	D3183	SHEET 3 OF 4
TITLE	BRACKET ASSEMBLY	SCALE
		1:2



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

W/042193

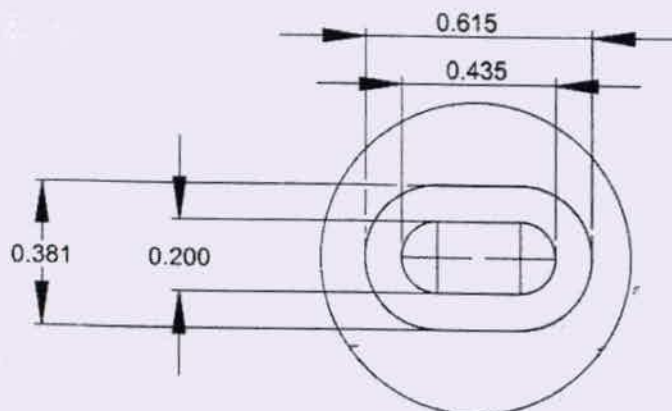
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04-05-01

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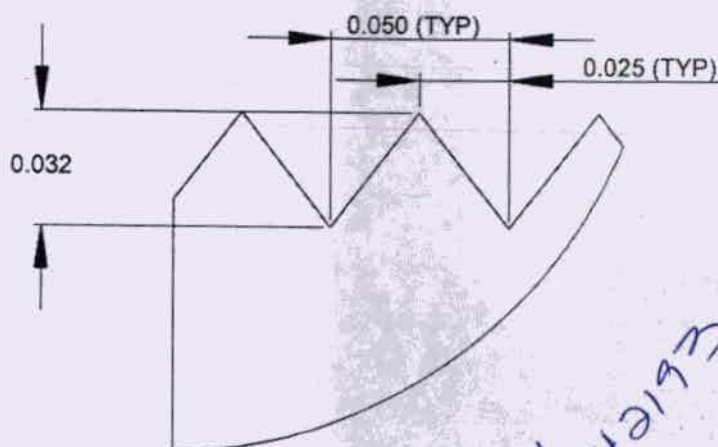


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



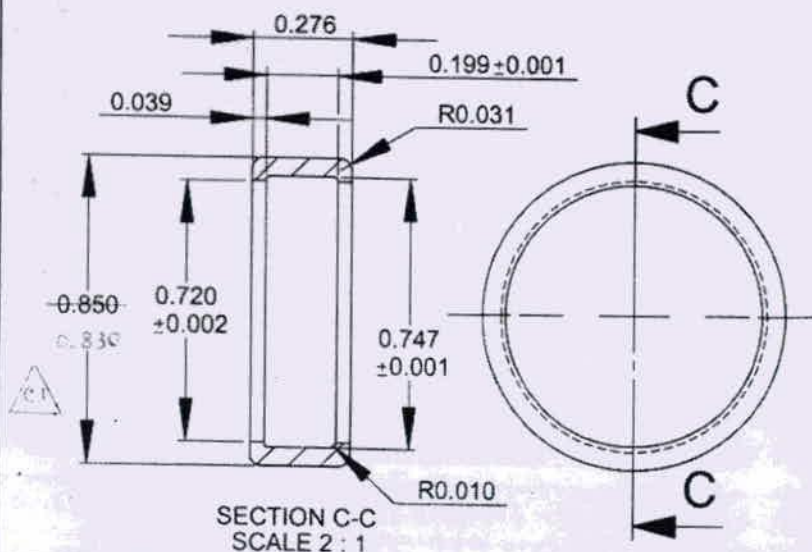
DETAIL A (2 : 1)

RELEASED
04.03.01



DETAIL B (20 : 1)

Wb 42193



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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DART AEROSPACE LTD		Work Order:	42193-1
Description: Bracket		Part Number:	D3183-3
Inspection Dwg: D3183	Rev: C1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	R.187	✓			
R0.063	+/-0.010	R.063	✓			
0.182	+/-0.010	.178	✓			
0.070	+/-0.010	.073	✓			
0.100	+/-0.010	.099	✓			
Ø0.201 x 0.100	+/-0.010	Ø.197 x .103	✓			
0.182	+/-0.010	.178	✓			
5.32	+/-0.030	5.32	✓			
5.036	+/-0.010	5.035	✓			
2.120	+/-0.010	2.120	✓			
1.290	+/-0.010	1.285	✓			
0.365	+/-0.010	.364	✓			
0.218	+/-0.010	.210	✓			
1.030	+/-0.010	1.030	✓			
1.90	+/-0.030	1.88	✓			
1.012	+/-0.010	1.016	✓			
Ø0.201 x 0.100	+/-0.010	Ø.200 x .097	✓			
0.786	+/-0.010	.786	✓			
Ø0.392	+0.002/-0.000	.393	✓			
R0.19	+/-0.030	R.187	✓			
3.954	+/-0.010	3.956	✓			
0.162	+/-0.010	.162	✓			
R0.19	+/-0.030	R.187	✓			
R0.25	+/-0.030	R.25	✓			
4.26	+/-0.030	4.26	✓			
2.080	+/-0.030	2.110	✓			
1.155	+/-0.010	1.150	✓			
0.162	+/-0.010	.166	✓			
0.36	+/-0.030	.360	✓			
-0.615	+/-0.010	.615	✓			
0.435	+/-0.010	.438	✓			
0.200	+/-0.010	.205	✓			
0.381	+/-0.010	.381	✓			
0.032	+/-0.010	.031	✓			

Measured by:	<i>mm</i>	Audited by:	<i>JL</i>	Prototype Approval:	N/A
Date:	08/12/08	Date:	08/12/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-043	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	06.03.09	Dwg Rev update	KJ/JLM	
D	08.01.28	0.182 dimension removed	KJEC/DD	<i>[Signature]</i>